

ABSTRACT OF THE DISCLOSURE

One object of the present invention is to provide a method for cutting a corrugated card board sheet in which continuous trimmed pieces are formed over an order change period, thereby preventing
5 meandering of the sheet without increasing manufacturing cost.

A method in accordance with the present invention is a method for cutting a continuous work sheet being fed along a feed line of a cutting machine using a slitter which is disposed in the feed line and is moveable in upper and lower directions, wherein when the
10 slitter is transferred from its previous cutting position to its new cutting position in response to an order change of the continuous work sheet, the continuous work sheet is cut in a manner that a trimmed piece forms a continuous strip, the method comprising: providing a trimming means disposed along the feed line in a
15 position spaced apart from the slitter, the trimming means being movable in upper and lower directions, and the trimming means including a slitter blade being pivotable around an axis disposed vertically relative to the surface of the continuous work sheet, moving the slitter from its previous cutting position to a position
20 spaced apart from the surface of the continuous work sheet, while moving the trimming means toward the cutting position for the continuous work sheet, whereby the trimming means cuts the trimmed piece formed by the slitter in the previous cutting process, and moving the slitter toward the cutting position for the
25 continuous work sheet, while moving the trimming means from the cutting position for the continuous work sheet to a position spaced apart from the surface of the continuous work sheet, whereby the slitter begins to cut the continuous work sheet, whereby the

trimmed piece is formed by the trimming means in such a manner that the trimmed piece formed in the previous cutting process and the trimmed piece formed in the new cutting process are continuous.

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